

Work Order ID 53138

October 23, 2009 8:39:16 AM



Page 1

Item ID: D3907-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bushing

Start Date: 23/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 02/11/2009 Req Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan: PL

Date: 27-10-27

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3907

A

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

Machine as per Folio FA823
& Dwg D3907

Dwg Rev: A

Folio Rev: N/A

Deburr

0.00

5/10/24

40

φ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

5/10/24

40

φ

P10
L.P.

Work Order ID 53138

October 23, 2009 8:39:16 AM



Page 2

Item ID: D3907-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bushing

Start Date: 23/10/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	mf 09/10/26			40	0		
130 Packaging Packaging	Identify as per dwg & Stock Location: basket Memo	0.00 0.00				PD 09.10.26			
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							109-10-28 PL 09-10-26 40

Picklist Print

October 23, 2009 8:39:21 AM

Page 1

Work Order ID: 53138

Parent Item: D3907-1RevA

Parent Item Name: Bushing


Comments:

Start Date: 23/10/2009

Required Date: 02/11/2009

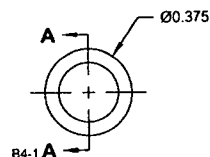
Start Qty: 40.00

Required Qty: 40.00

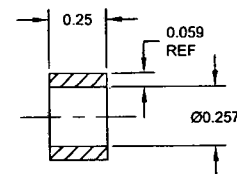
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No			100	f	45.4645	1.2000			
												
304 ROUND BAR 0.375												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	45.46447895	
110166	3.32	
110472	6.41	
112058	0.31317895	
112473	35.4213	

1.2 DT SA 09/10/24



D3907-1 BUSHING



SECTION A-A C5-1

SUPPLY COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 53138

PL 09-10-23


RELEASED
09/03/11

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL ROD
REF DART SPEC M304R

OR: AISI 304/316 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

A		NEW ISSUE		AJS	09.03.11			
REV.		DESCRIPTION			BY	DATE		
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN		AJS						
CHECKED					DRAWING NO.		REV.	
MFG. APPR.					D3907		SHEET 1 OF 1	
APPROVED					TITLE		SCALE	
DE APPR.					BUSHING (BASKET REPAIR)		N	
DATE					09.03.11		COPYRIGHT © 2009 BY DART AEROSPACE LTD	

W/O: 53138		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-10-28	W/O hensch	Add Dwg D3907 Rev. A to the dwg box. perm change	HA	09/10/28		05-10-28	05-10-28

Part No: D3907-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

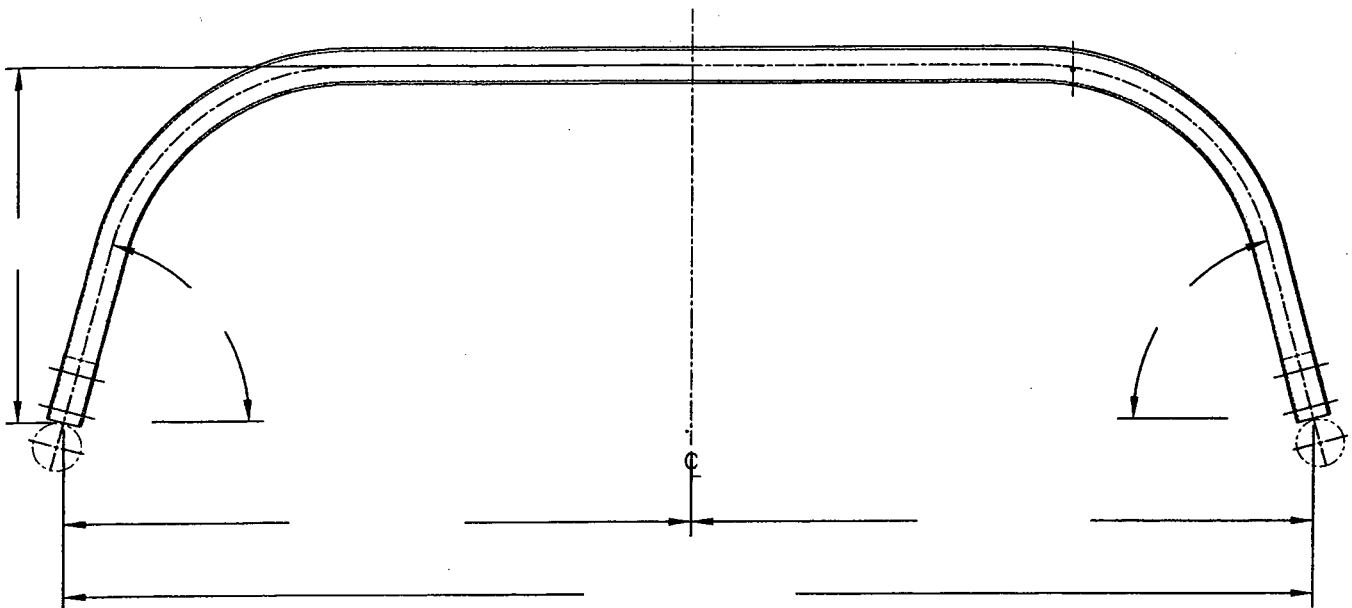
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53115
Description: Crosstube Low Fwd (205/212/412)		Part Number: D212-664-107
Inspection Dwg: D212-664-147 Rev: A		Page 1 of 1

Required Dimension	Min	Max
Height	20.79	21.05
1/2 Span	48.55	48.81
Angle	49	52
Total Span	97.1	97.62



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/JM	